

5/09

DART AEROSPACE LTD	Work Order:	22506
Description: Fuel Purge Canister	Part Number:	D3262-041
Dwg: D3262 Rev. A	Qty:	12
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty								
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3	PH	05.02.22	10								
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: <u>M16764</u>	BE	05.02.23	15								
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	BE	05.02.24	15								
4	QC2	Inspect parts as they come off the CNC machine	BE	05.02.24	15								
5	QC8	Second check	ML	05.02.24	15								
6	MV	Deburr	FE	05.02.24	15								
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <u>M15362</u>	BE	05.03.07	12								
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td></td><td>Aluminum Rod</td><td><u>M15855</u></td></tr></table>	Qty	Part Number	Description	Batch	A/R		Aluminum Rod	<u>M15855</u>	BE	05.03.08	8
Qty	Part Number	Description	Batch										
A/R		Aluminum Rod	<u>M15855</u>										
9	QC5	Inspect work to Step 8	PH	05.03.10	8								
10	PG	Issue P/O: For Liquid Penetrant inspection as per Dwg D3262, QSI-036 & as per ASTM E1417 Level 1 Possible Supplier: NDT Copy of NDT results is required. PRESSURIZE TO 10 PSI AND SUMERGE UNDER WATER TO CHECK FOR LEAKS. 05.03.10											
11	RG	Receive and Inspect for transit damage as per Dwg D3262 Ensure copy of NDT results are attached.											
12	QC6- QC5	Inspect for damage and ensure results are as per Dwg D3262 Inspect work for step 10	PH	05.03.10	8								
13	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.03.14	8								
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	ML	05.03.15	8								
15	QC3	Inspect Powder Coat	CL	05/03/18	8								
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CL	05/03/18	8								
17	AC	Cost / part: <u>137.13</u>	Sur	05.04.01	8								
18	DC	Close W/O <u>137.13</u> Inspect Level 21	PH	05.04.28	8								

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/21	8	DT scrap "new product development" process	AB	doekey	AB	AB 05/04/21	AB 05/04/21	AB 05/04/21

Part No: D3262-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AB Date: 05/04/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22506
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262	Rev: A B A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.064 x 45°	✓			
0.45	+/-0.030	0.445	✓			
R0.06	+/-0.030	0.063	✓			
0.080 0.090	+/-0.010	0.092	✓			0.080 does not add-up
0.33	+/-0.030	0.328	✓			
5.030	+/-0.010	?				Not on Dwg
4.125	+/-0.010	?				"
2.375	+/-0.010	?				"
0.688	+0.005/-0.000	0.690	✓			wrong tol.
3.250	+/-0.005	3.251	✓			
Ø5.030	+0.010/-0.000	?				Not on Dwg
Ø0.875	+0.005/-0.000	Ø.873	✓			Does not need to be +0.005 -0.000
Ø0.516	+0.005/-0.000	Ø.517	✓			
Ø5.190	+0.005/-0.000	Ø.5.191	✓			
0.83	+0.015/-0.000	0.086	✓			
Ø0.580	+0.005/-0.000	Ø.582	✓			wrong. tol.

Measured by: <i>EC</i>	Audited by: <i>ml</i>	Prototype Approval:	N/A
Date: 05-02-22	Date: 05/02/22	Date:	N/A

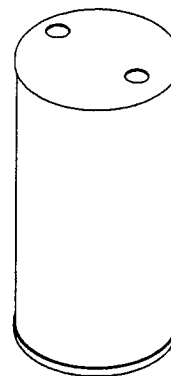
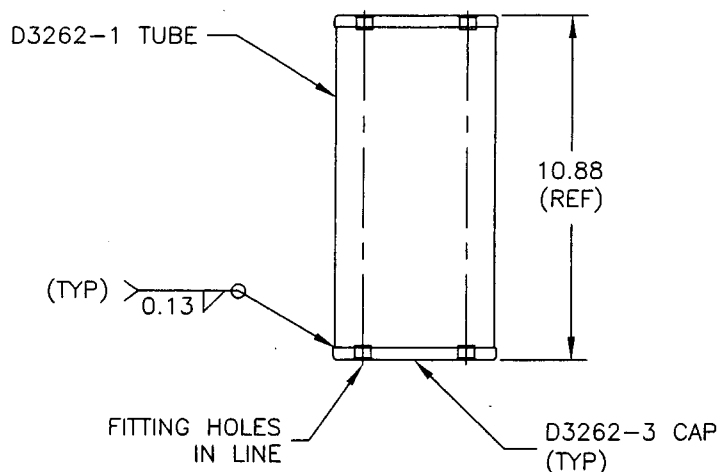
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	<i>[Signature]</i>

RELEASED
04/09/03

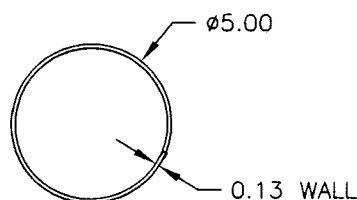
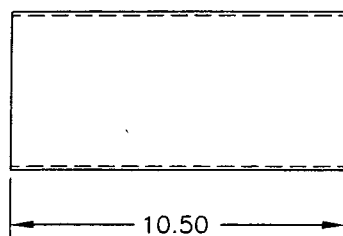


PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	



D3262-041 CANISTER ASSEMBLY



D3262-1 TUBE

D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22506

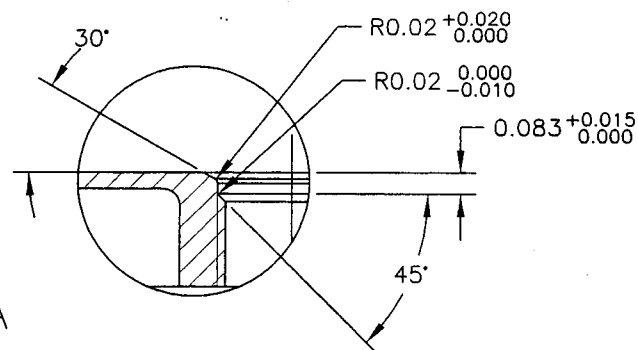
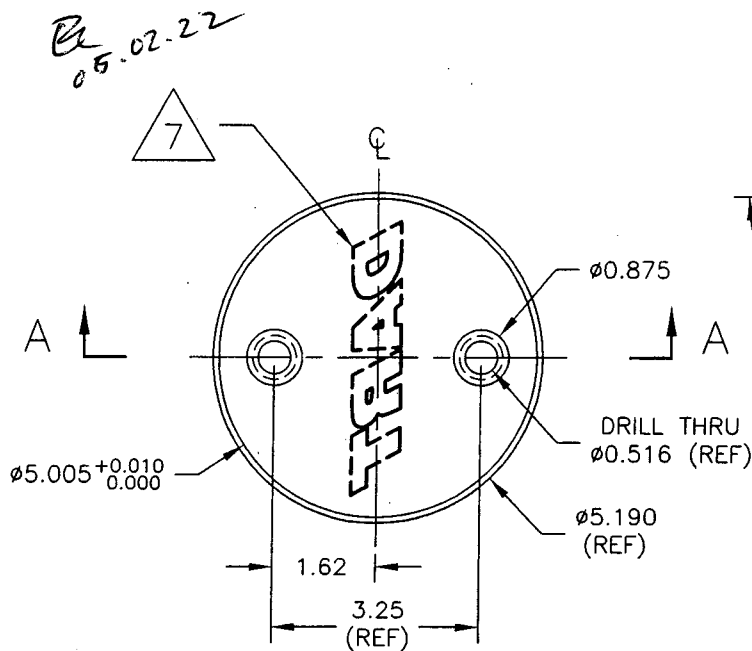
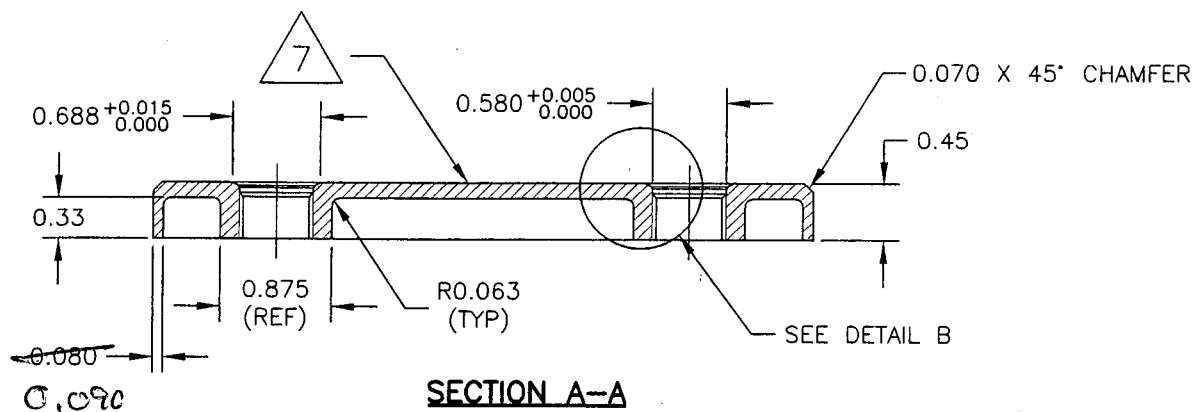
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3



D3262-3 CAP

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22506

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
11:07 am

Work Order No : 0022506
Project Name : D3262-041
Project For : WK509
Work Order Type : Main
Main WO Number :
House Part Number : D3262-041
Description : Fuel Purge Canister
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 02-22-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00